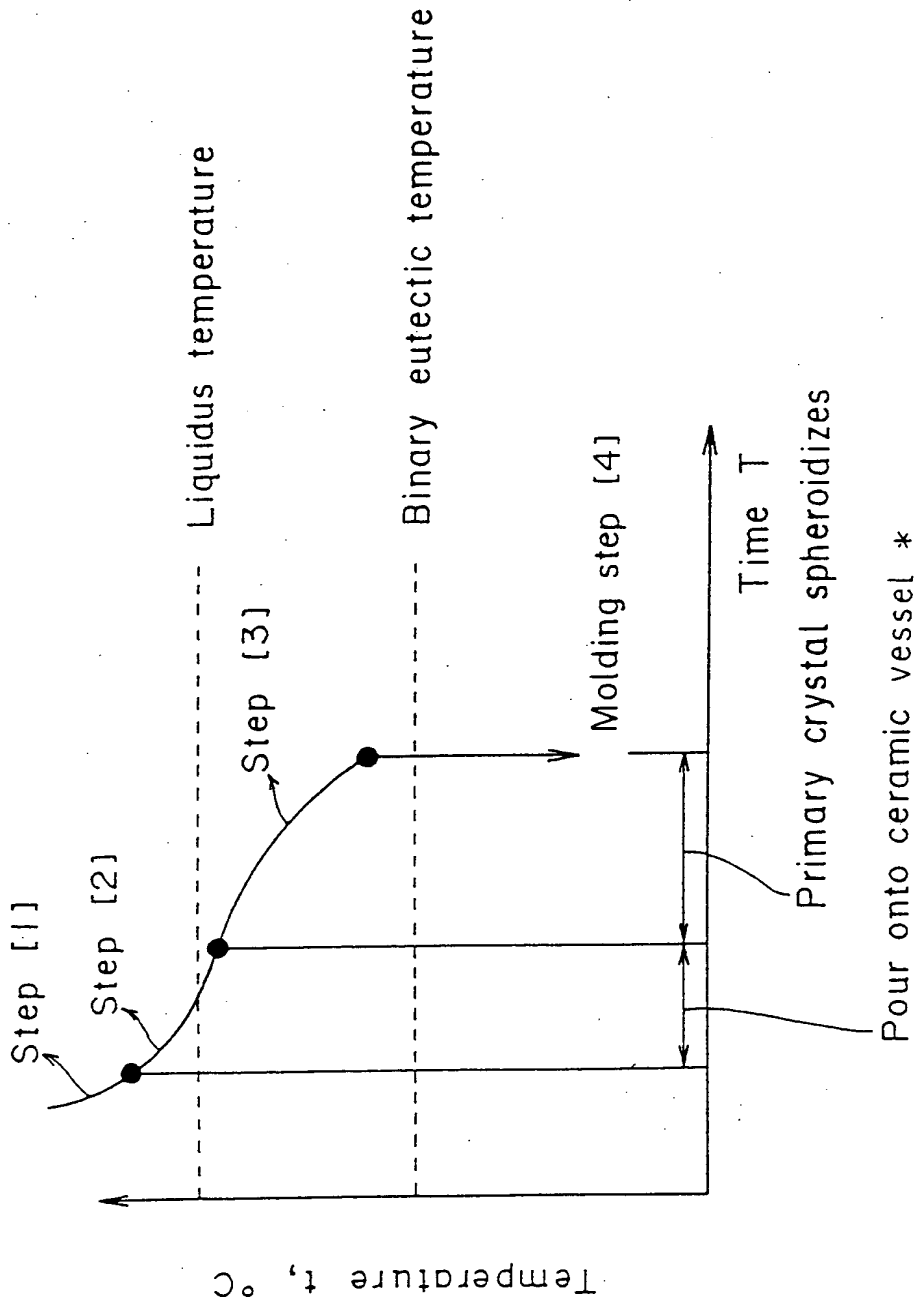


FIG. 1(a)



* With or without cooling jig

FIG. 1 (b)

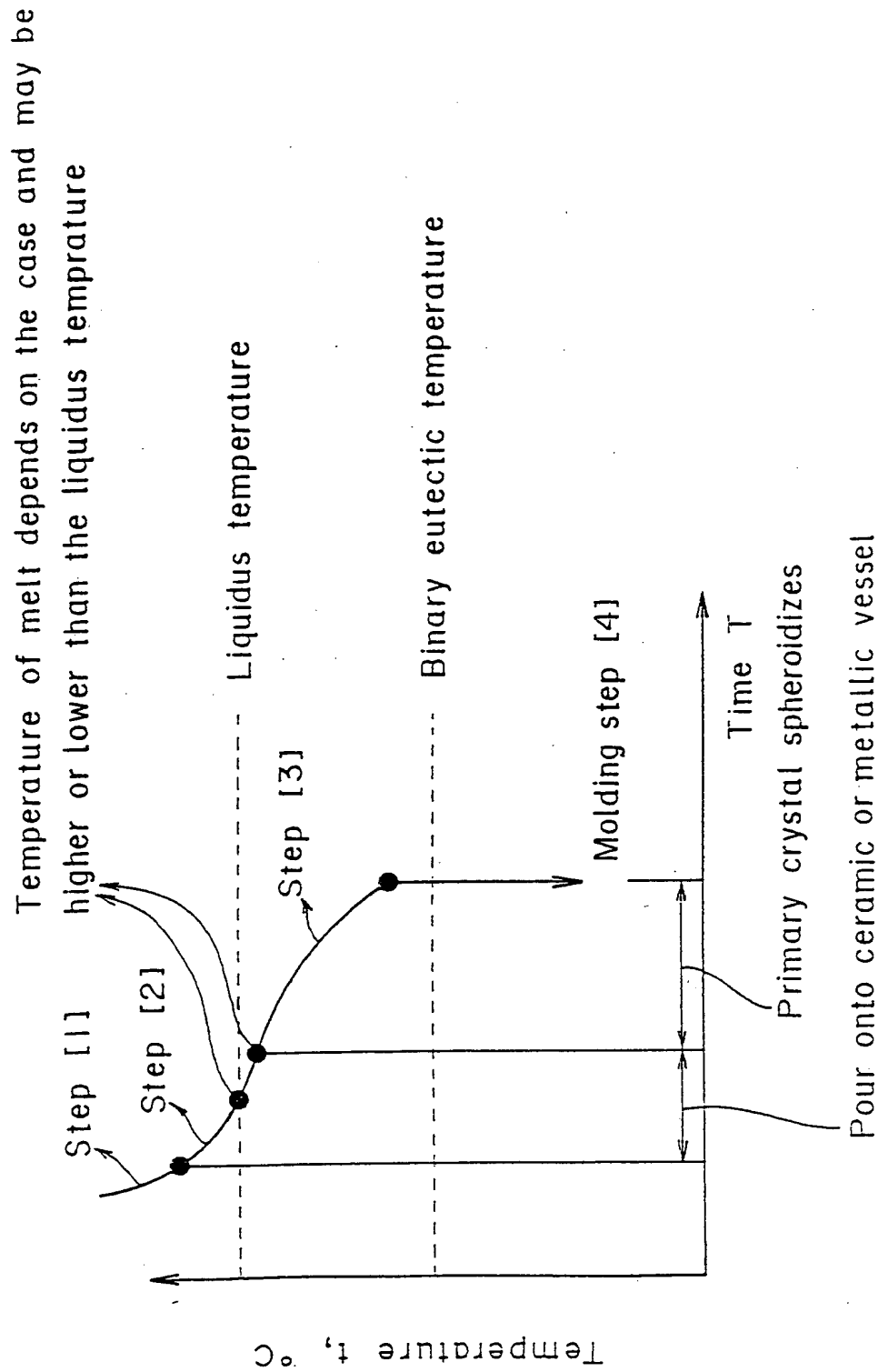
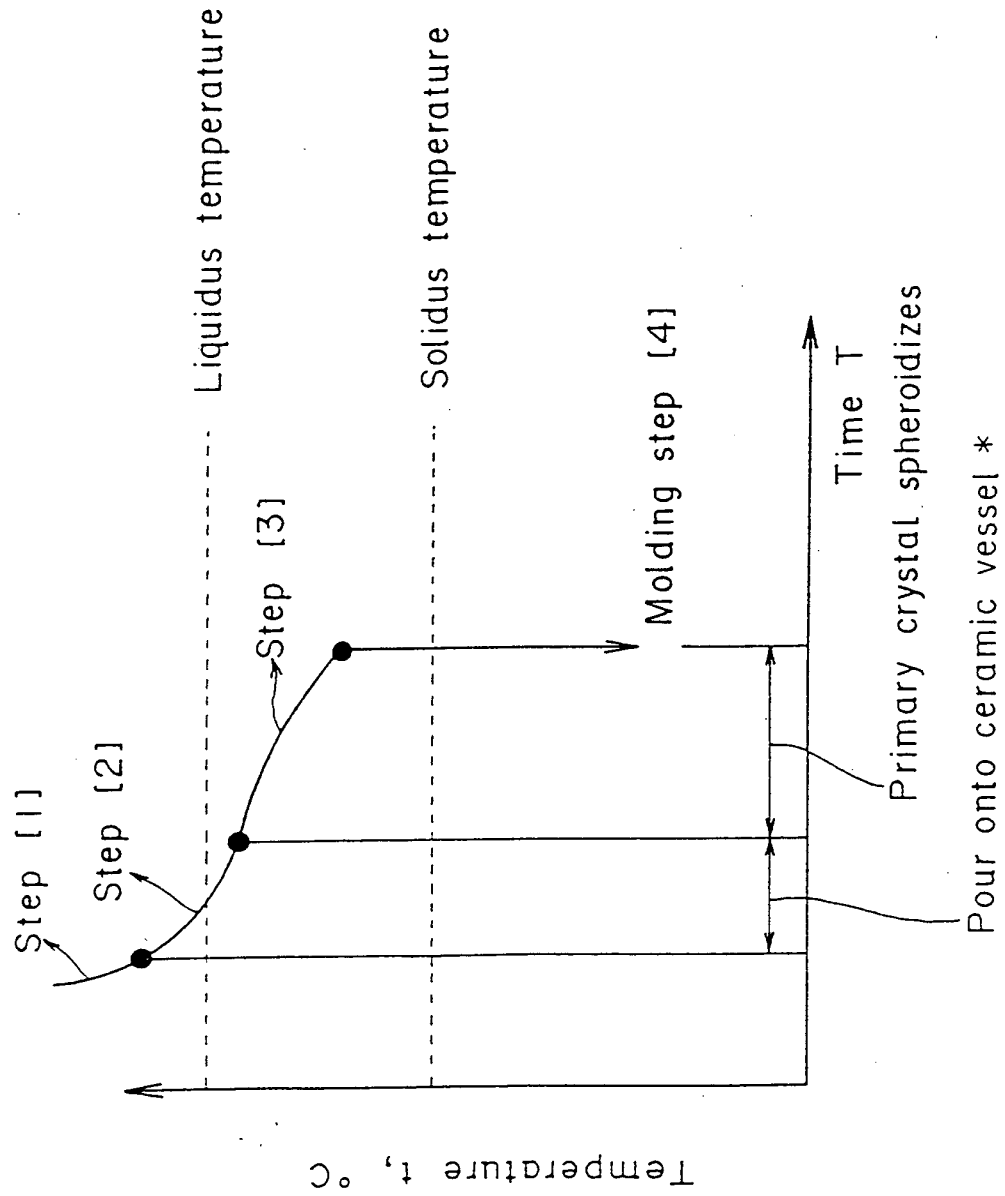


FIG. 2(a)



*With or without cooling jig

FIG. 2(b)

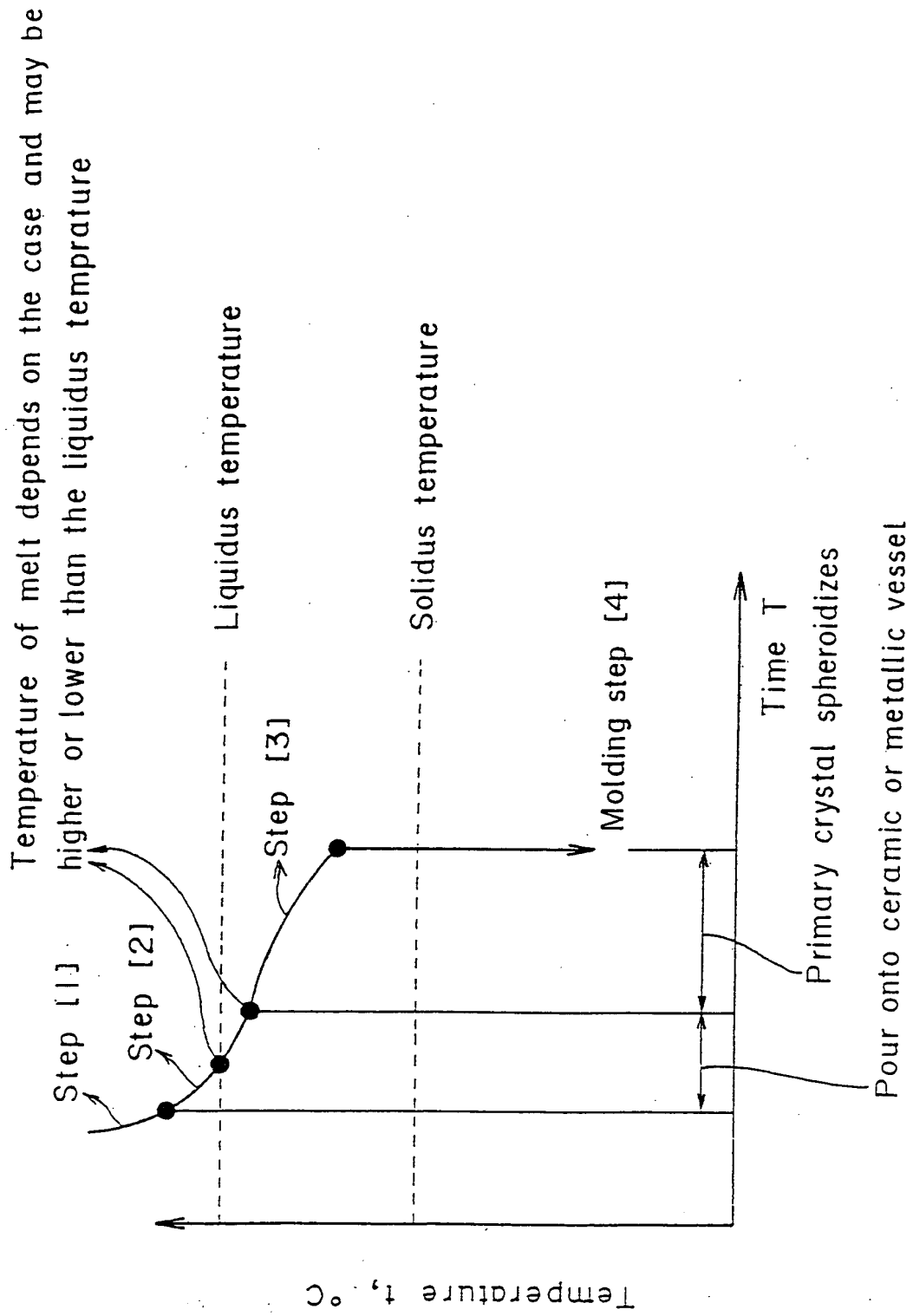


FIG. 3(a)

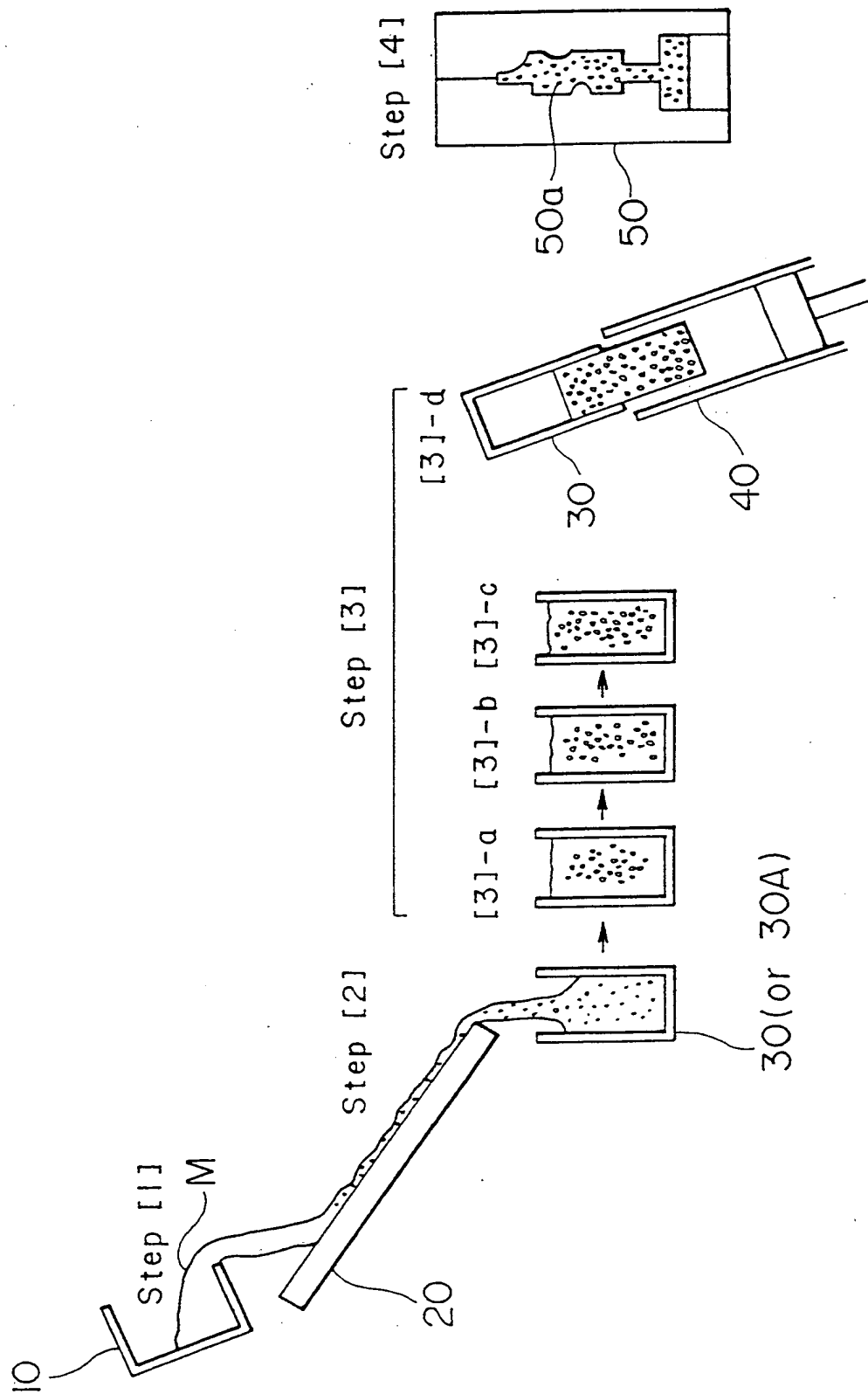


FIG. 3(b)

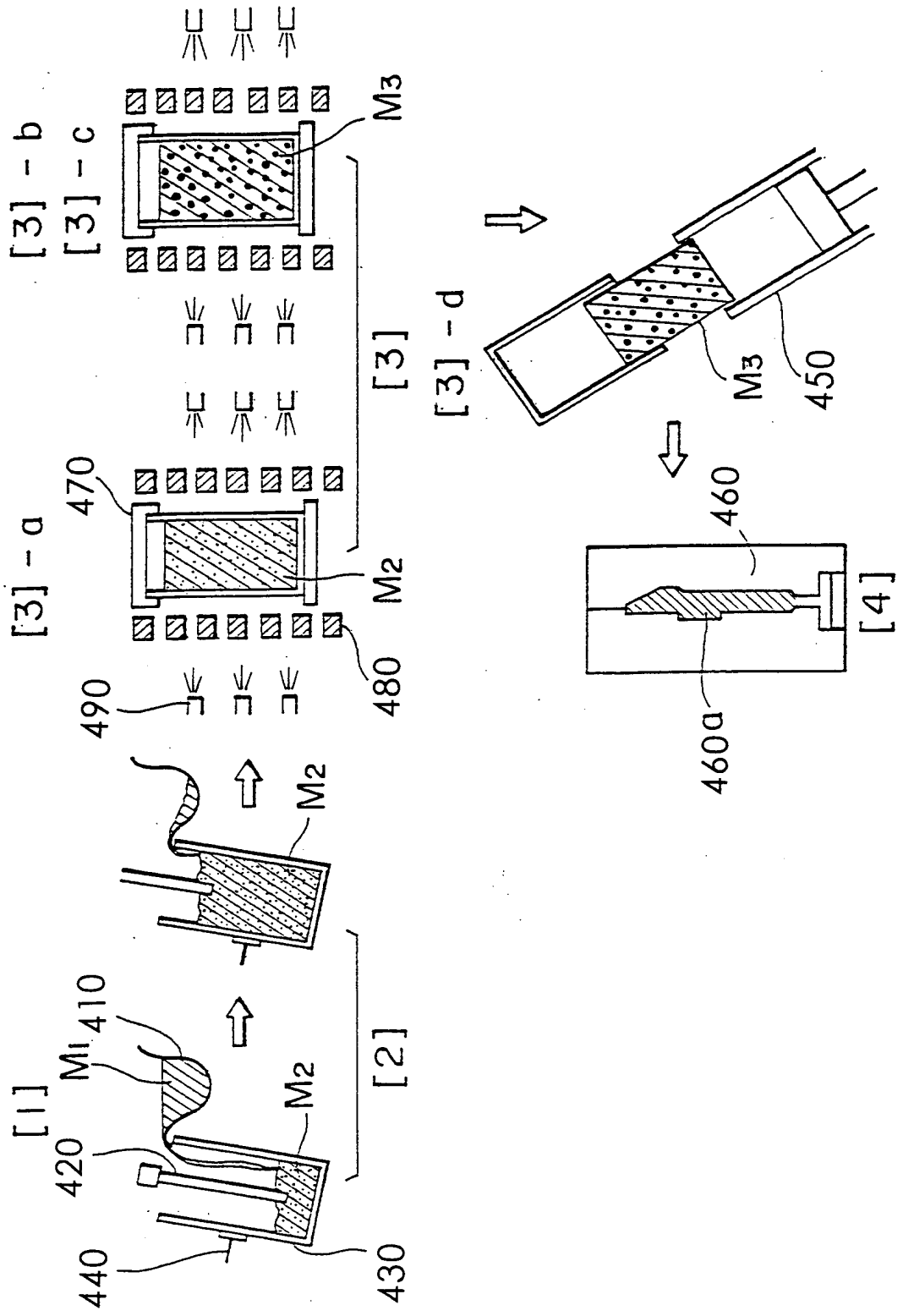


FIG. 5(a)

Superheated to no more than 100°C
(without cooling jig) or 300°C
(with cooling jig) above liquidus temperature

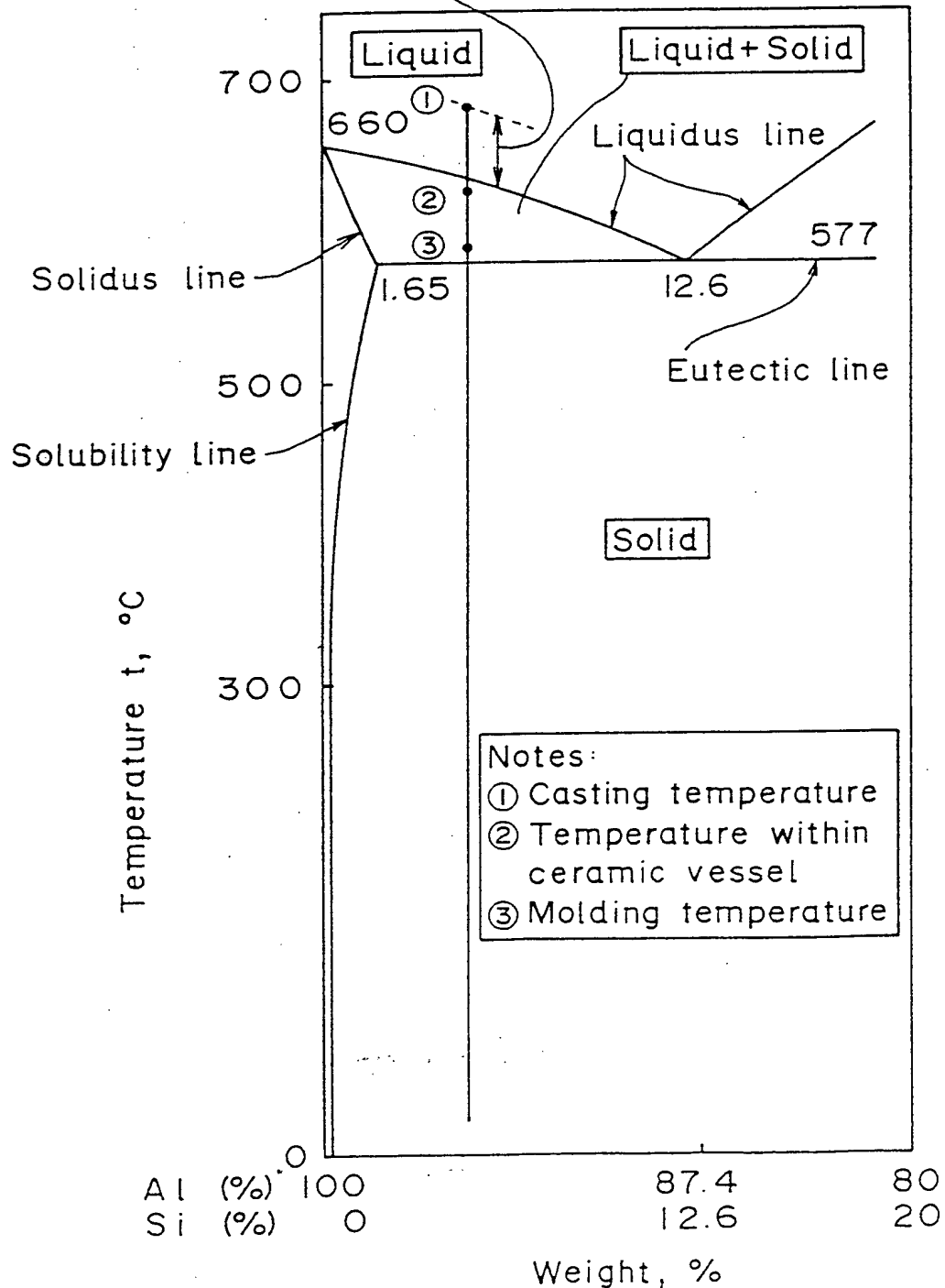


FIG. 5 (b)

Temperature of melt depends on the case and may be higher or lower than the liquidus temperature

Superheated to no more than 50°C above liquidus temperature

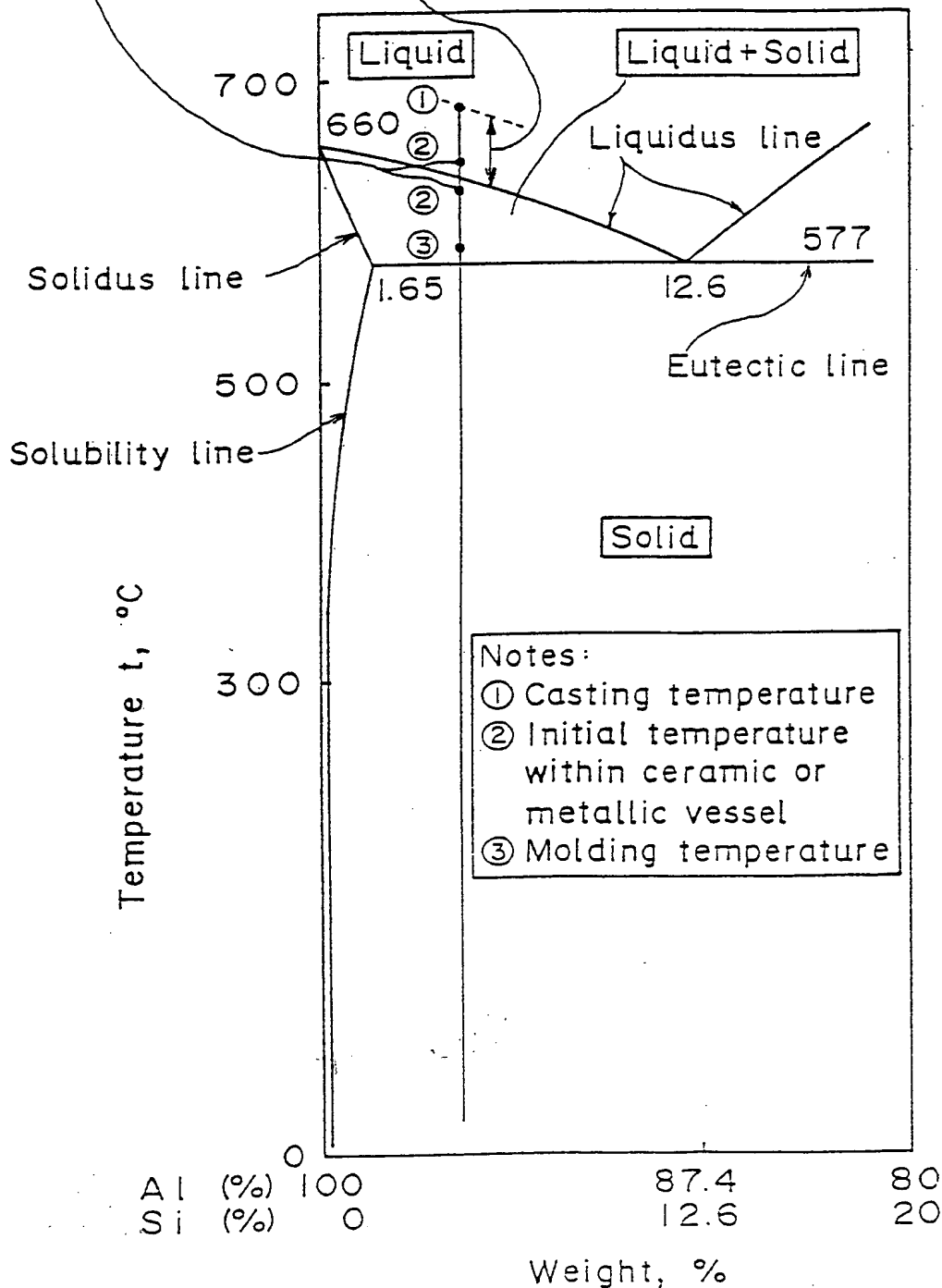


FIG. 6(a)

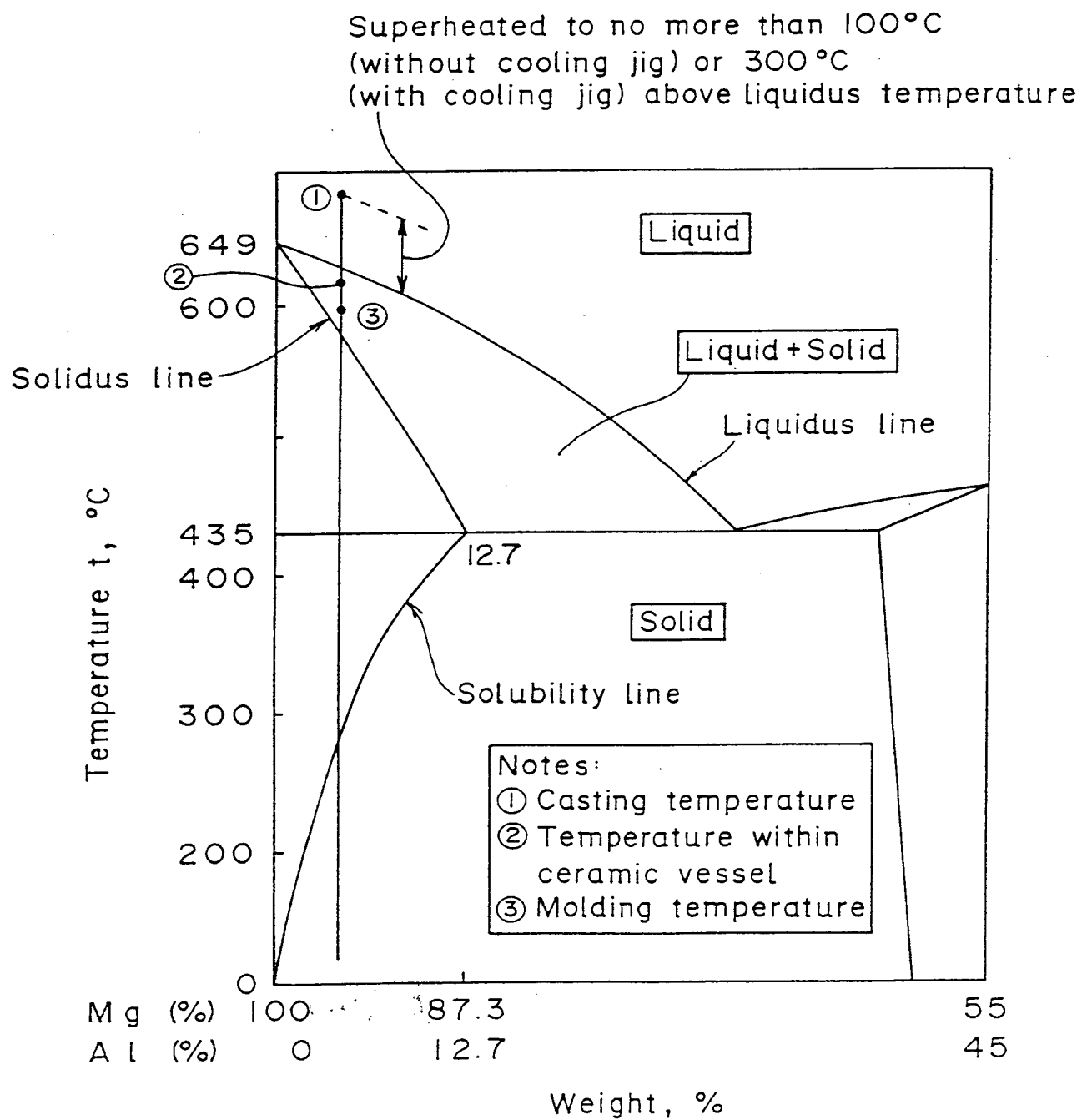


FIG. 6 (b)

Temperature of melt depends on the case and may be higher or lower than the liquidus temperature

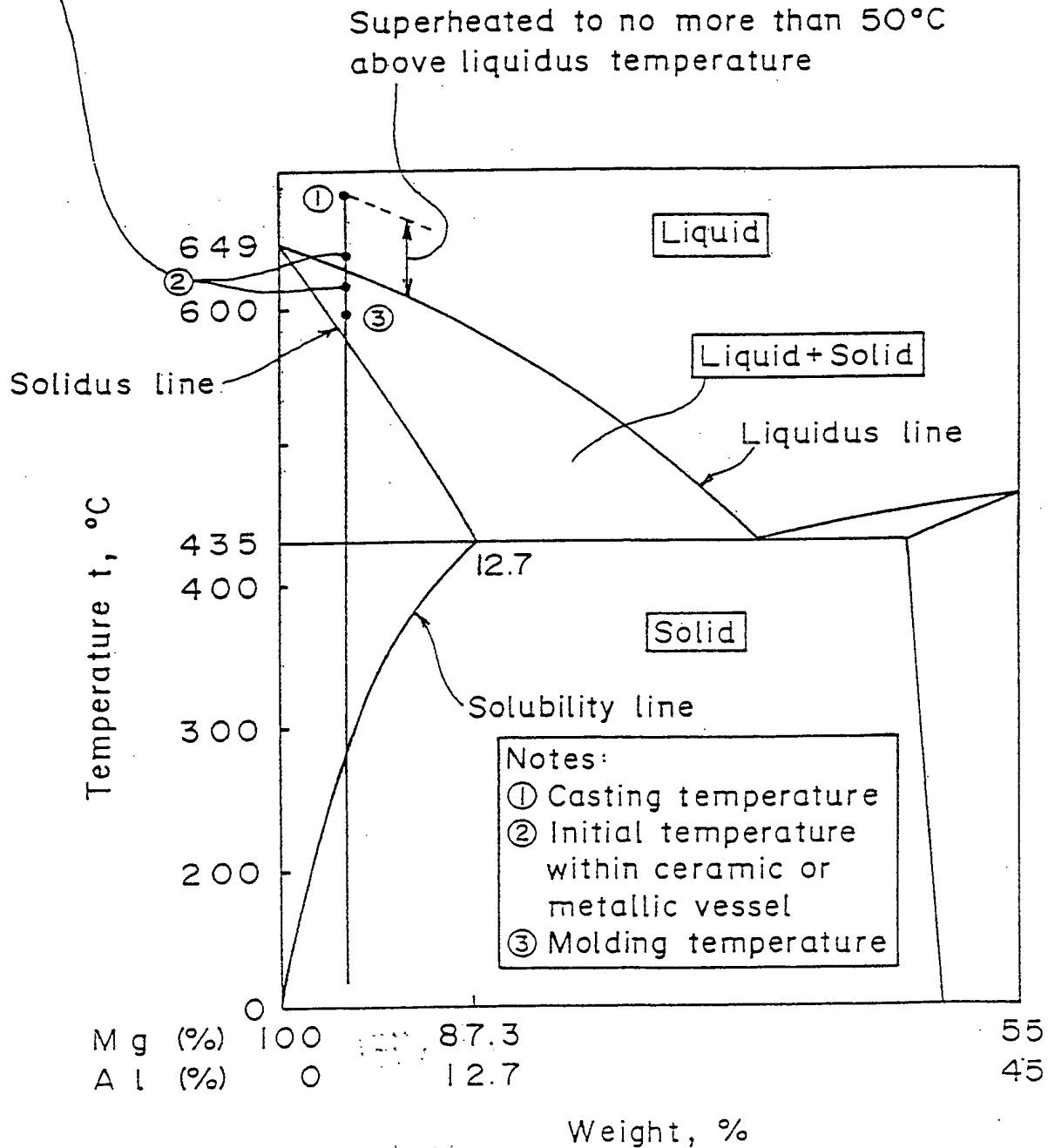


FIG. 7(a)

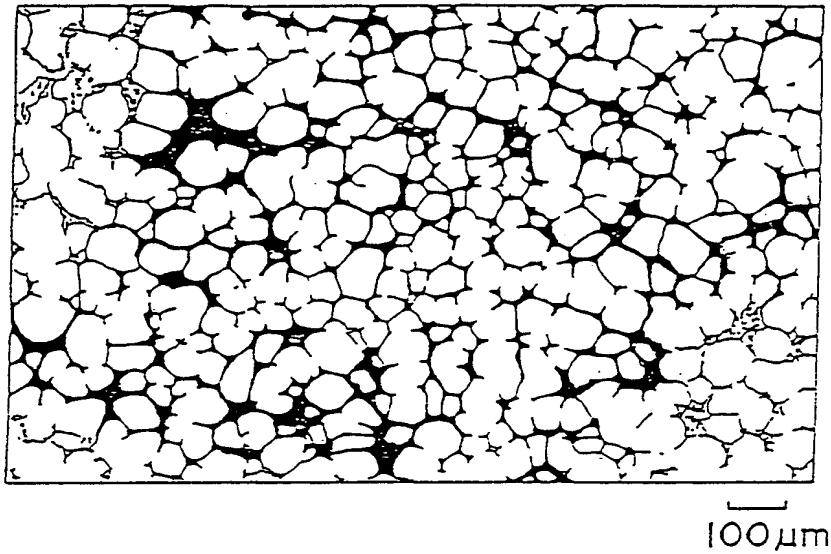
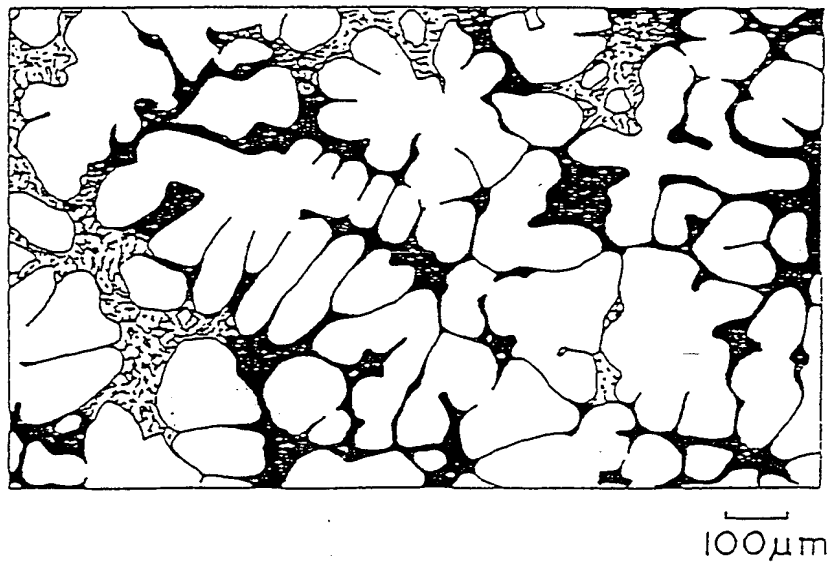
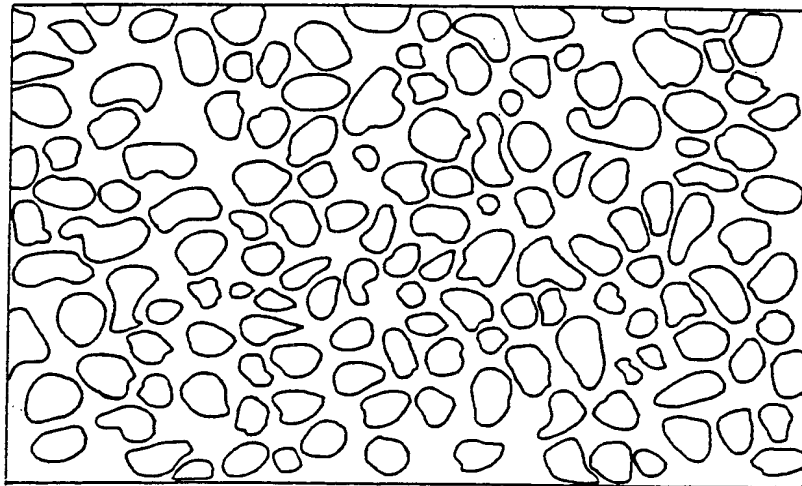


FIG. 8(a) Prior Art



APPROVED	D.G. FIG.	
BY	CLASS	SUBCLASS
DRAFTSMAN		



200μm

FIG. 7(b)



200μm

FIG. 8(b)
PRIOR ART

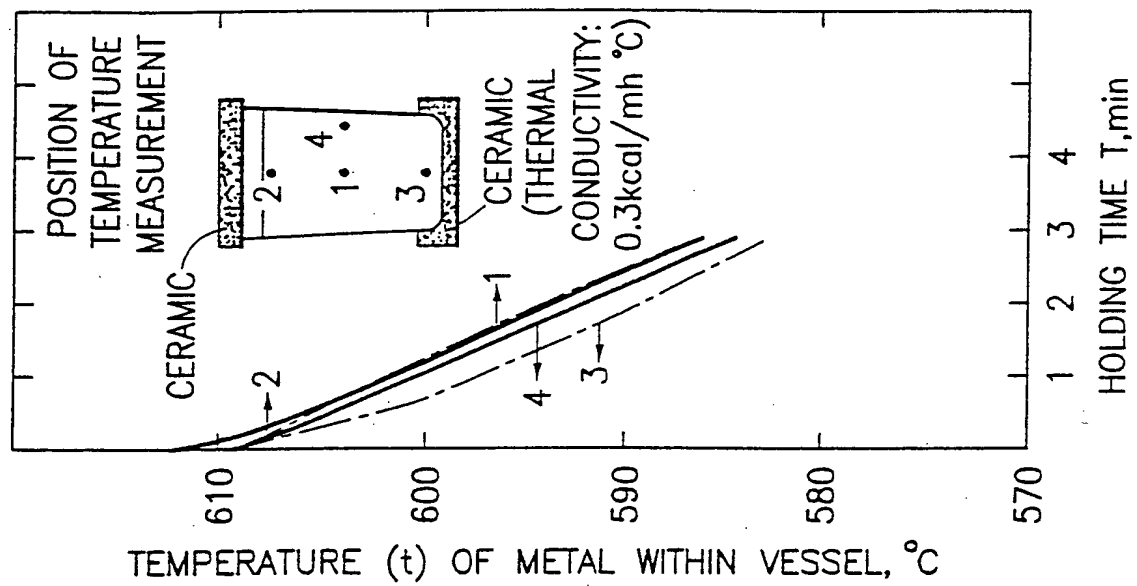


FIG. 75(b)

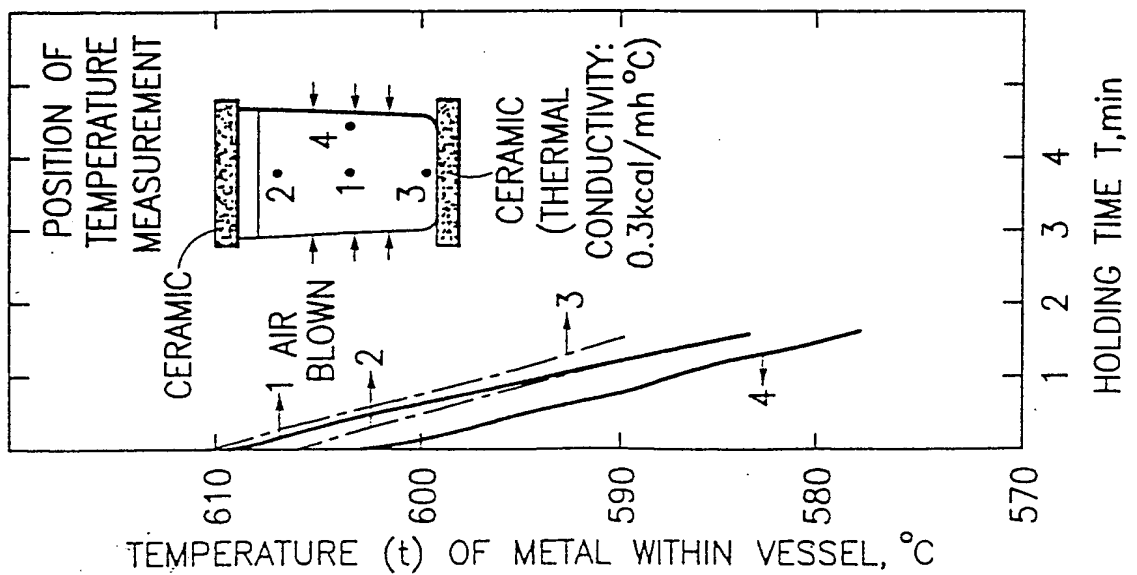
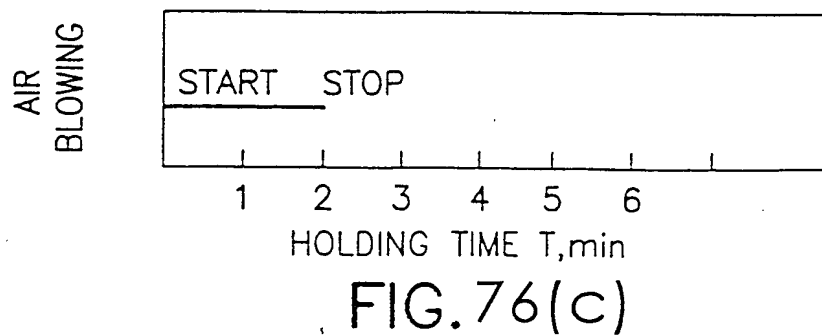
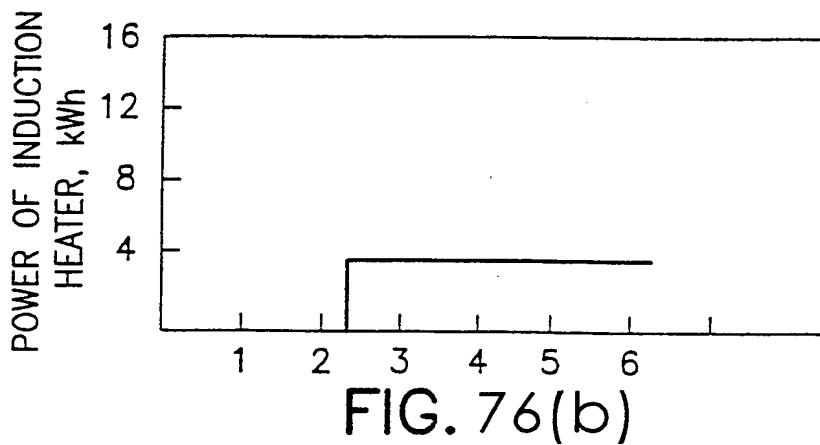
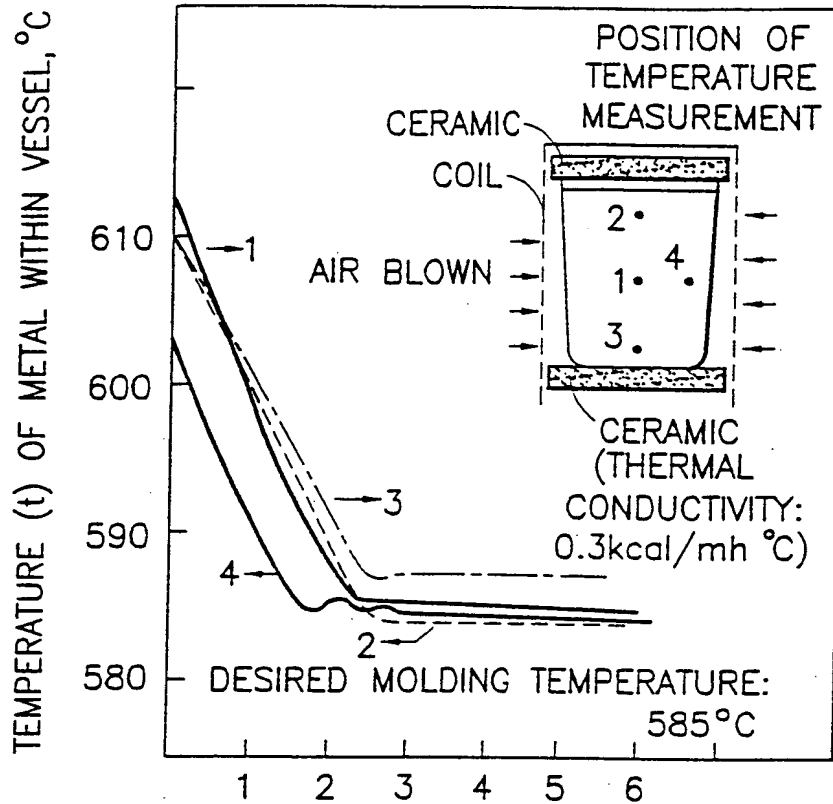


FIG. 75(a)



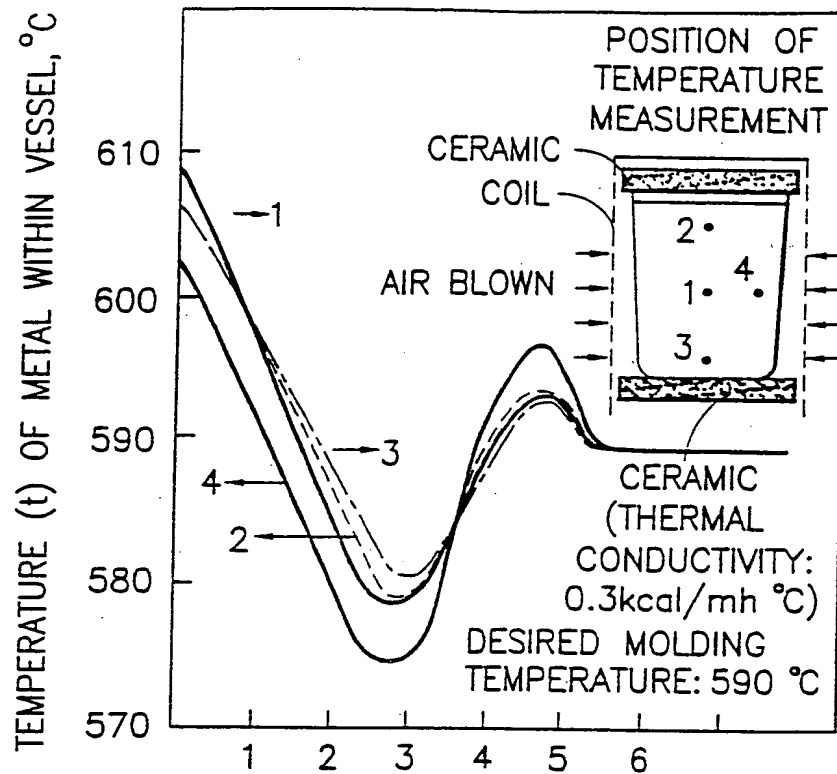


FIG. 77(a)

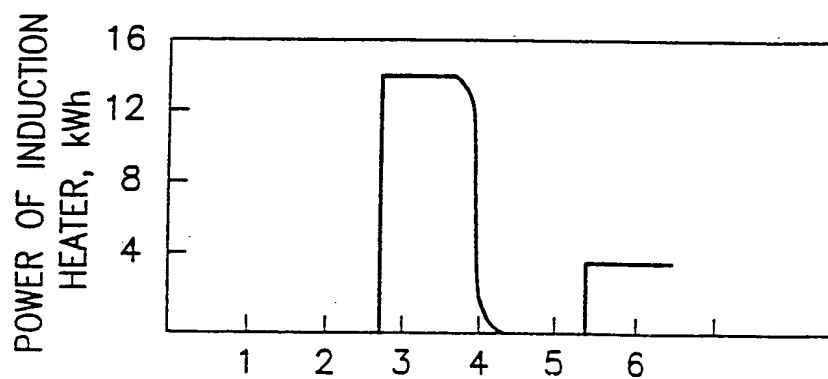


FIG. 77(b)

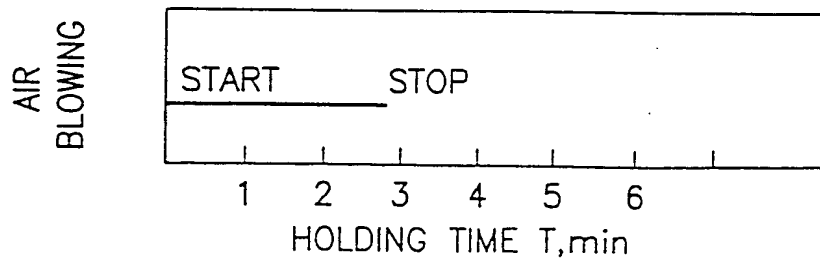
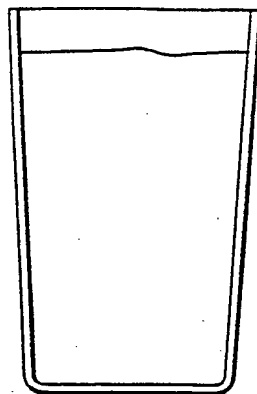


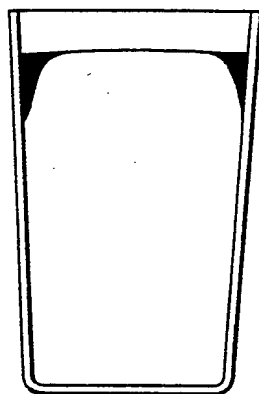
FIG. 77(c)

APPROVED	C. G. FAS.	
BY	CLASS	SUBCLASS
DRAFTSMAN		



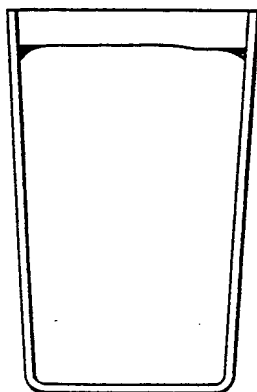
WHEN MOLDING TEMPERATURE IS REACHED

FIG. 78(a)



WHEN HEATED AND HELD WITH rf INDUCTION
HEATER (AT 8 kHz) FOR 20 min AFTER
MOLDING TEMPERATURE WAS REACHED

FIG. 78(b)



WHEN HEATED AND HELD WITH rf INDUCTION
HEATER (AT 40 kHz) FOR 20 min AFTER
MOLDING TEMPERATURE WAS REACHED

FIG. 78(c)

FIG. 79

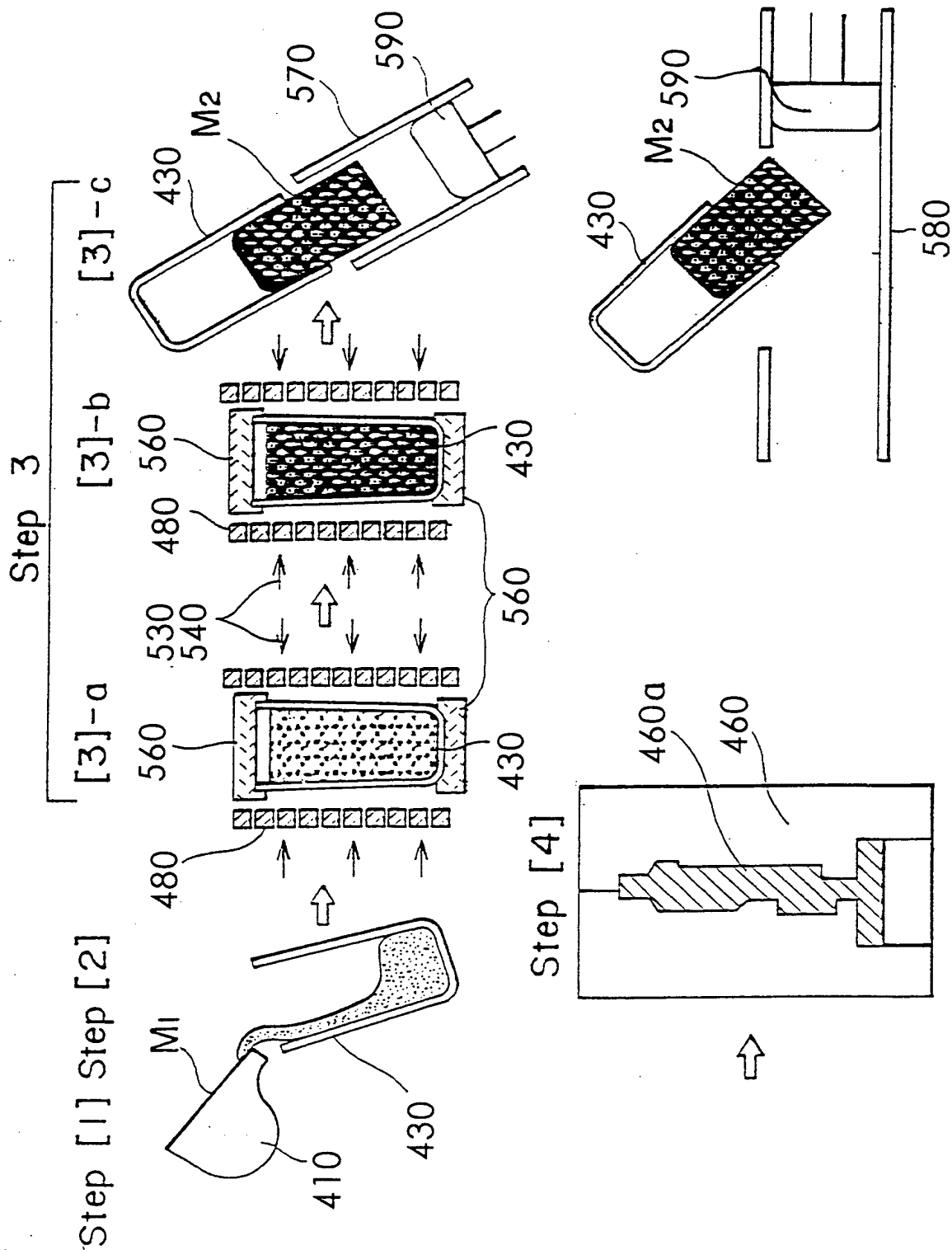


FIG. 80
AC4CH(Al-7Si-0.3Mg-0.15Ti)

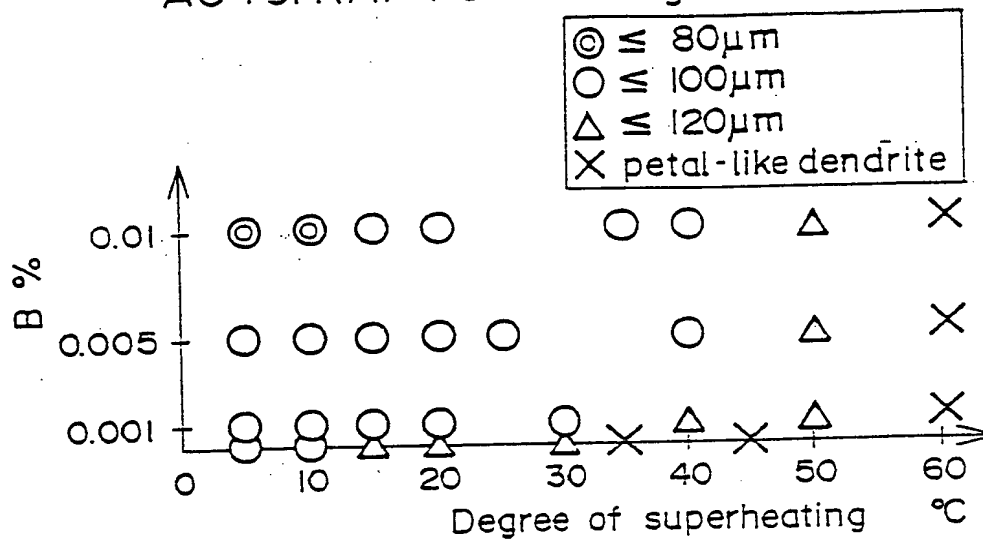
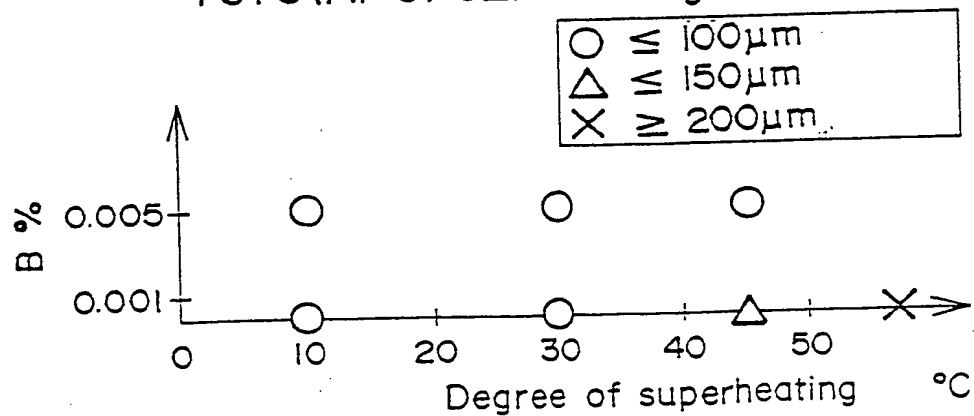
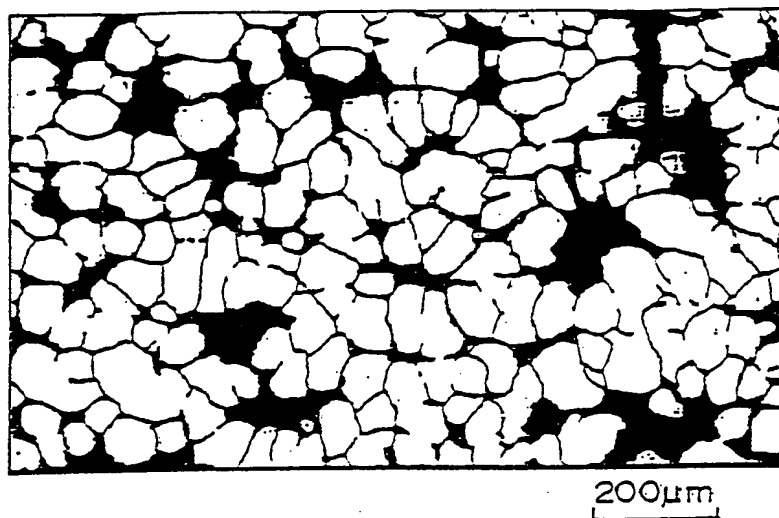


FIG. 81
7075(Al-5.5Zn-2.5Mg-1.6Cu-0.15Ti)



APPROVED	C. A. G.	
BY	CLASS	SUBCLASS
DRAFTSMAN		

FIG. 82



APPROVED	DATE	BY	CLASS	SUBCLASS
DRAFTSMAN				

FIG. 83

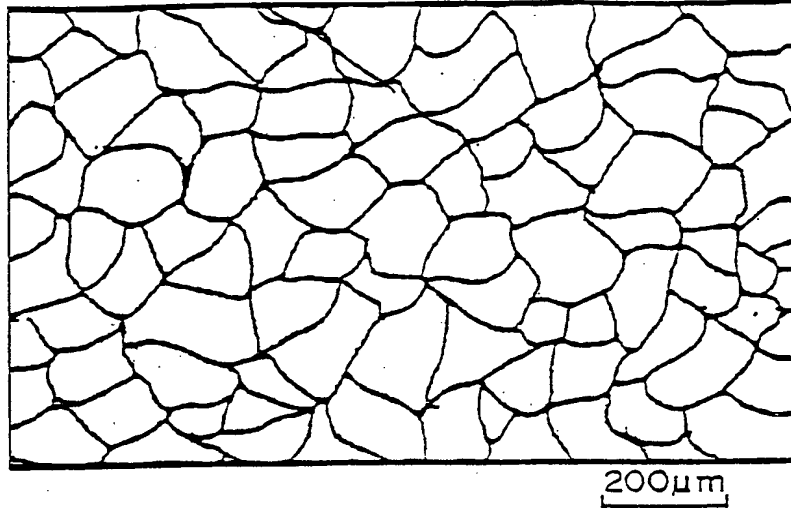


FIG. 84

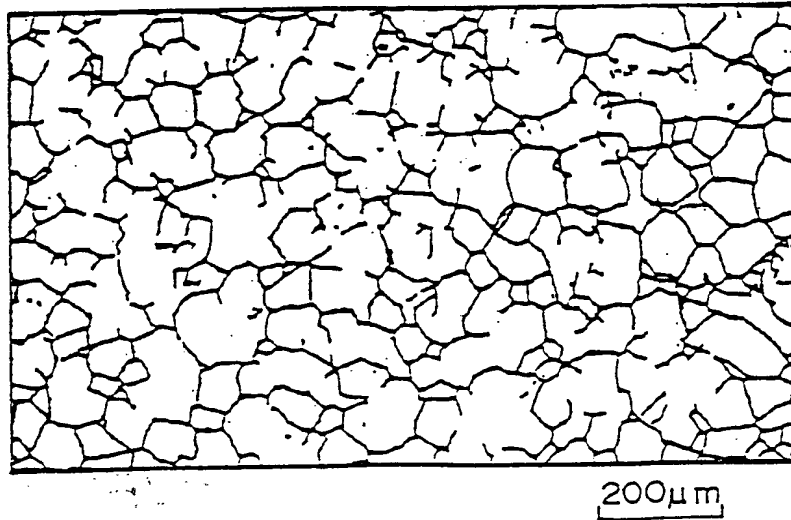


FIG. 85 Prior Art

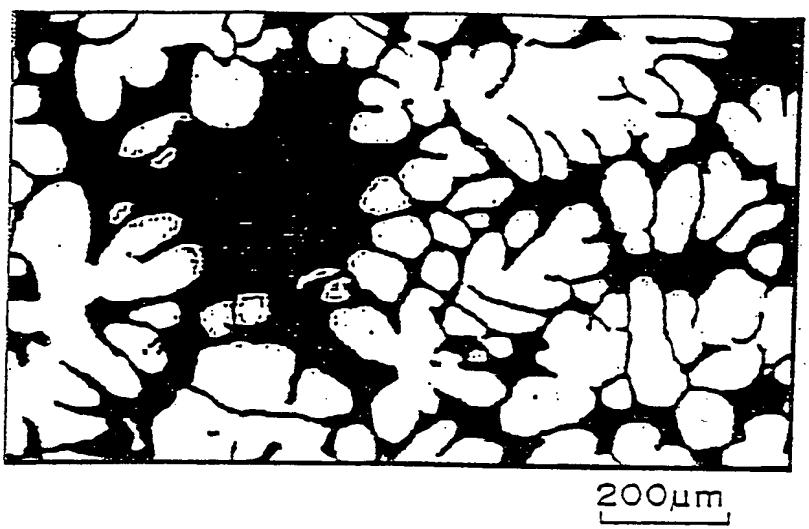


FIG. 86 Prior Art

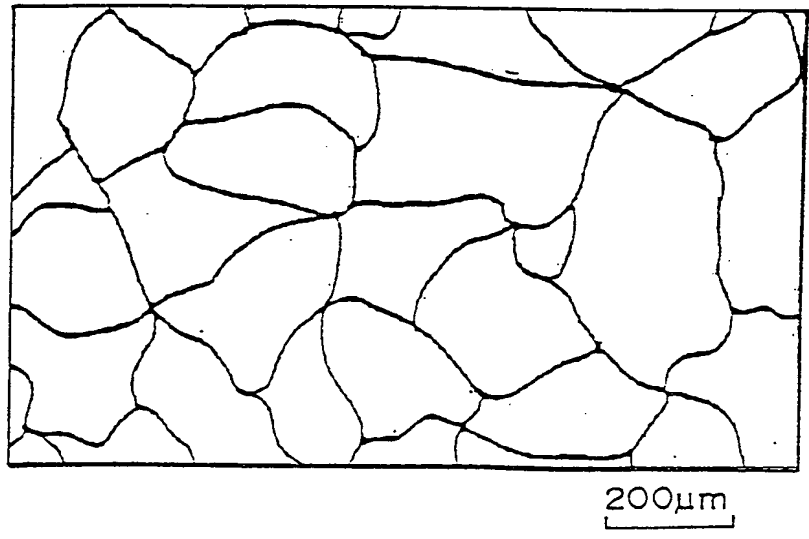


FIG. 87 Prior Art

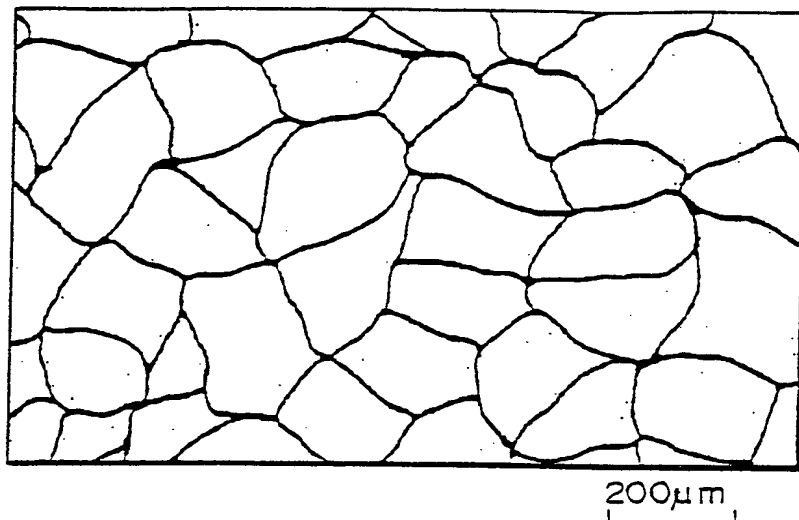


FIG. 88 Prior Art

